AMENDMENTS TO THE CLAIMS:

The listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claims 1-14 (Cancelled)

15. (Original) The method of manufacturing a quick turn in-line roller skate wheel including:

selecting a hard hub with an annular bearing housing having a pair of annular load bearing flanges of a combined predetermined axial width;

selecting a casting mold having upper and lower mold sections, said lower mold section configured with an annular mold cavity section defining a central lower hub cavity section and an outer lower tire body cavity section, said tire cavity section including a bottom wall extending radially outwardly from said hub section and formed with a downwardly and outwardly sloped narrowing section extending to a bottom maximum width ring and then turning radially outwardly to curve upwardly and radially outwardly to a juncture surface, said upper mold section being constructed to mate with said lower mold section and formed with a downwardly opening tire body cavity section having a wall aligned with said terminus and curving upwardly and radially inwardly to a top maximum width ring spaced from said bottom maximum width ring to form a maximum body width greater than said predetermined load bearing flange axial width and projecting radially inwardly to terminate in an annular sprue wall;

placing said hub in said lower hub cavity section;

positioning said upper mold section on said lower mold section;

selecting a back pin and engaging it with said hub to position an annular back pin sculpture shoulder angling upwardly and axially outwardly from said load bearing flange to terminate in an annular sprue wall spaced annularly from said first sprue wall to form an annular sprue inlet;

selecting a prepolymer of the type which will curve to a flexible mass and introducing it through said sprue inlet to fill said body cavity to form a resilient tire body;

removing said back pin and said upper mold section; and

removing and trimming said wheel.

16. (Original) The method as set forth in claim 15 wherein:

said back pin is selected having an annular downwardly opening cavity for nesting therein of the upper axial side of said hub.

17. (Original) The method as set forth in claim 15 wherein:

said back pin is selected with a sealing lip disposed radially inwardly of said sculpture wall and configured to sealingly engage said load bearing flange.

18. (Original) The method of claim 15 wherein:

said hub is selected of first and second sections having first and second joint sections and includes the steps of:

joining said first and second sections before placing said hub in said mold.

19. (Original) The method of claim 15 wherein:

the step of selecting said hub includes selecting said first and second sections of the type cooperating to, when joined, form an annular shell disposed concentrically thereabout to define a lightening cavity; and

the step of placing said hub in said mold includes placing said annular shell in said tire body section.

Claims 20-40 (Cancelled)

41. (New) The method of claim 15 wherein:

said introducing includes selection of a polymer of the type which cures to a hardness less the hardness of the hub.

42. (New) A quick turn skate wheel manufactured by the method set forth in claim 1.

43. (New) A cast, quick turning urethane in-line skate wheel comprising:

a hard hub formed with a cylindrical bearing housing for mounting on bearings and including a radially outwardly projecting support disk;

annular support flanges projecting axially outwardly on opposite sides of said disk to form respective radially outwardly facing load support surfaces and cooperating to a predetermined combined axial width;

a relatively soft, flexible annular urethane tire body mounted on said load bearing flanges having encasing the said disk, said tire body being configured with an annular tread section having oppositely disposed tread walls sloping axially outwardly and radially inwardly from a maximum axial width greater than said predetermined axial width but no greater than .900 inches; and

said tire body further including a narrowing body section interposed between said tread section and said load bearing surface and configured with opposite narrowing walls sloping axially and radially inwardly toward one another from said maximum axial thickness to the opposite ends of the respective said flanges and configured with radially inwardly facing beads abutting the respective said support surfaces whereby said tread section will flex under load to facilitate gripping of a supporting surface to resist slipping or sharp turns of skate and said narrowing body section will provide a reduced intertia reducing resistance to changes in angular acceleration.

44. (New) The wheel of claim 43 wherein:

said tire body is formed with said maximum axial width substantially to .850 inches.

45. (New) The wheel of claim 43 wherein:

said support disk projects radially outwardly a distance from said load bearing surface to project at least to the radial center of said tire body.

46. (New) The wheel of claim 43 wherein:

said tire body section is oval in transverse cross section.

47. (New) The wheel of claim 43 wherein:

said tire body is constructed with an outside diameter of 2.835 inches.

48. (New) The wheel of claim 43 wherein:

said predetermined combined axial width is 0.56 inches.

49. (New) The wheel of claim 43 wherein:

said hub is formed with said support disk having an axial diameter of 2.150 inches;

said annular support flanges project outwardly on the opposite sides of said disks sufficiently far to form a predetermined axial width of 0.560 inches; and

said urethane tire body is configured with a maximum diameter of 2.385 inches and maximum axial width of .850 inches.

50. (New) The wheel of claim 43 wherein:

said hub is formed with a through bore having a bearing glands opening outwardly to the axial opposite sides thereof.

51. (New) The wheel of claim 43 wherein:

said stabilizer ring is formed at is radial outer extent with a circumferentially continuous rim.

52. (New) The wheel of claim 43 wherein:

said annular support flanges are disposed at a radius of about 1.5 inches.

53. (New) The wheel of claim 43 wherein:

said disk has an outer diameter of 2.150 inches; and

said tire body has an outer diameter of 2.385 inches.

54. (New) The wheel of claim 43 wherein:

said tire body is constructed to form tire sections on the axial opposite side of said support flange; and

said tire sections having a large degree of flex under load to facilitate gripping of the support surface.

55. (New) The wheel of claim 43 wherein:

said tire body is constructed such that said body will flex when loaded along a load vector at an acute angle to the control plane of the flange to a greater degree than when loading along a vector in such plane.